

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009813**Date Inspected:** 27-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

Bay 2-

This QA Inspector observed the following work in progress: SAW welding of weld joint 006 located on Floor Beam FB3061-001. ZPMC welder was identified as 250050. ZPMC QC is identified as Chen Xi. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-B-L2c-S-2.

This QA Inspector observed the following work in progress: SAW welding of weld joint 026 located on Floor Beam FB3010-001. ZPMC welder was identified as 207237. ZPMC QC is identified as Chen Xi. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-B-L2c-S-2.

Bay 3-

This QA Inspector observed the following work in progress: FCAW welding of weld joint 125 located on Floor Beam FB023-010. ZPMC welder was identified as 044830. ZPMC QC is identified as Chen Xi. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2232-TC-U4b-F.

Bay 5-

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA Inspector performed Ultrasonic Testing (UT) of the areas previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members were identified as OBG Traveller Rail. The weld identification numbers are as follows: TR5A-PP13-002, TR1E-PP28-009, 010, TR5C-PP17-005, 006, TR6B-PP18-003 and 004. Ultrasonic Testing was performed with 0.375 inch diameter transducer with a 70 degree wedge. Due to lack of scanning area between welds, limited testing in the 1st leg was performed on the above mentioned welds.

Bay 11-

This QA Inspector observed the following work in progress: SAW welding of ESD1-FESA4-1 A/C 82 doubler plate weld located on the East Tower Skin Plate E. ZPMC welders was identified as 066484. ZPMC QC is identified as Peng Guo. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-4332-TC-P4-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation occurred between QC and QA this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
